Ship Aug 12 2014

Work Order ID 122914

Tuesday, August 05, 2014 3:30:13 PM

122914

Item ID: D3371-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Tail Rotor Pedal Lock **Stop** *NS2*

Start Date: 7/29/14 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 7/29/14 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 14-8-5 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3371	Rev B								

120 0.00

120

Small Fab

Small Fab

Small Fab 2 FF 14-08-07

Memo 0.00

ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT1- Press dowel pins as per Dwg D3371, then assemble hinge.Ensure that assembly opens & closes smoothly. Identify as D3371-051.
2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	M125715

130 0.00

130

Small Fab

Small Fab

Small Fab 2 FF 14-08-07

Memo 0.00

Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-045

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D3371-041 **Accept** *N900040100* **Setup Start** *NS1*
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Item Name: Tail Rotor Pedal Lock
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140		0.00							
140	Small Fab					2			FF 14-08-07
Small Fab	**Memo**	0.00							
Small Fab	1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371. 2- Identify as D3371-041 & attach keys 3- Record the Key Number on page 4								
150	QC5- Inspect part completeness to step on W/O	0.00	Evaluator	1		(2)		DAS 38 9-89	14/08/07
150									
QC	**Memo**	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: PPP	0.00							
160	1x122914					2		DAS 33 9-89	14-08-07
Packaging	**Memo** 1x123275	0.00							
Packaging									

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Other

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170 QC Quality Control	**Memo**	0.00							

MLS 14-08-11

14.8.8

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

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Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
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FAULT CATEGORY

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☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

Tuesday, August 05, 2014 3:30:18 PM

Work Order ID: 122914

122914

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/29/14 **Required Date:** 7/29/14

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID / Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028		Purchased	No			120	Each	54.0000	2	4			
238-028									**		FF	14-08-07	
3/16" Dowel Pin .5" long													
				Location			**Loc Qty**		**Loc Code**				
				ST396			54						
					106673		32			4			
					108114		22						
AN526C832R6		Purchased	No			120	Each	38.0000	4	8			
AN526C832R6									**		FF	14-08-07	
Screw													
				Location			**Loc Qty**		**Loc Code**				
				ST327			38						
					16612		38			8			
D3371-1		Manufactured	No			120	Each	12.0000	1	2			
D3371-1									**		FF	14-08-07	
Pedal Lock Base													
				Location			**Loc Qty**		**Loc Code**				
				ST498			12						
					106255		6			2			
					109066		1						
					109067		3						
					70040		2						
D3371-3		Manufactured	No			120	Each	16.0000	1	2			
D3371-3									**		FF	14-08-07	
Pedal Lock Cover													
				Location			**Loc Qty**		**Loc Code**				
				ST498			16						
					104353		16			2			

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WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

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DISPOSITION

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AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
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FAULT CATEGORY

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Work Order ID: 122914 *122914*
Parent Item: D3371-041 *D3371-041*
Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/29/14 **Required Date:** 7/29/14
Start Qty: 2.00 **Required Qty:** 2.00

D3373-7	Manufactured	No		120	Each	7.0000	1	2
D3373-7 Cam Lock							**	FF 14-08-07

Location	Loc Qty	Loc Code	
ST064	7		2
880276 94791	7		

D3385-3	Manufactured	No		120	Each	54.0000	1	2
D3385-3 Hinge							**	FF 14-08-07

Location	Loc Qty	Loc Code	
ST036	54		
117534	54		2

CBL-1240	Purchased	No		130	f	229.7312	1.6666	4
CBL-1240 Cable							**	FF 14-08-07

Location	Loc Qty	Loc Code	
GA	229.7312266		
m128229	229.731227		4

CBL-460	Purchased	No		130	Each	526.0000	2	4
CBL-460 Loop Sleeve							**	FF 14-08-07

Location	Loc Qty	Loc Code	
GA	526		
125499	5		
m127811	3		
m128229	3		
m129007	24		
m129347	7		
m129753	484		4

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Work Order ID: 122914 *122914*
Parent Item: D3371-041 *D3371-041*
Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/29/14 **Required Date:** 7/29/14
Start Qty: 2.00 **Required Qty:** 2.00

D3384-1	Manufactured	No		130	Each	9.0000	1	2
D3384-1							**	FF 14-08-07
Cyclic Sock								

Location	Loc Qty	Loc Code	
ST500	9		
120103	9		2

HX-81	Purchased	No		140	Each	111.0000	1	2
HX-81							**	FF 14-08-07
1/4"-20 SHCS 3/8" long								

Location	Loc Qty	Loc Code	
ST262	111		
123436	90		
123499	21		2

NAS1149F0463P	Purchased	No		140	Each	1,573.000	2	4
NAS1149F0463P							**	FF 14-08-07
Washer								

Location	Loc Qty	Loc Code	
ST275	1573		
124859	12		
m123374	3		
m127832	1558		4

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DART AEROSPACE

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